

Work Order ID 75074

\*75074\*

Page 1

October-17-11 10:49:20 AM

Item ID: D2855 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Cap  
 Start Date: 17/10/2011 Start Qty: 50.00 \*50\* Cust Item ID:  
 Required Date: 28/10/2011 Req'd Qty: 50.00 \*50\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2855	Rev A

100 PURCHASING 0.00  
 \*100\*  
 Purchasing Memo 0.00  
 Purchasing Issue P/O: 15175 Cast per Dwg D2855 Material Release Note Required  
*Plum, South*

110 Receive & Inspect for Damage & Mat'l Certs 0.00  
 \*110\*  
 Packaging Memo 0.00  
 Packaging Ensure Material Release Note is attached

120 QC6- Inspect dimensions to drawing 0.00  
 \*120\*  
 QC Memo 0.00  
 Quality Control

11-10-11 (50)

11-11-11 (50)

11-11-11 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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October-17-11 10:49:20 AM

Item ID: D2855 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Cap  
 Start Date: 17/10/2011 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 28/10/2011 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- Drill as per Dwg D2855 using DT82352- Open holes to 19/64"3- Deburr								
140	QC5- Inspect part completeness to step on W/O	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*150*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: _____ FINISH TIME: _____								

W119480

3200F

4:00

11.12.21

counts  
x50

50x of M/14/2/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Required Date: 28/10/2011 Req'd Qty: 50.00 **\*50\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				50	BR	11-10-29	
170 <b>*170*</b> Small Fab Small Fab	Small Fab  Memo Install Inserts as per Dwg D2855	0.00 0.00				150	4	11/12/12/23	
180 <b>*180*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				200			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 75074

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October-17-11 10:49:20 AM

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>EP2</u>	0.00							
*190*									
Packaging	Memo	0.00				x50	4	44	12/06/23
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							12/11/23
*200*									
QC	Memo	0.00							
Quality Control									

12/01-23  
50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

October-17-11 10:49:24 AM

Page 1

Work Order ID: 75074

**\*75074\***

Parent Item: D2855

**\*D2855\***

Parent Item Name: Cap

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B00.06.22 Added receiving step & removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-225

Purchased

No

100

Each

1,173.000

2

100

**\*AI S7-1032-225\***

INSERT

ALS4-1032-225

X

Location

Loc Qty

Loc Code

ST282

1173

100896

146

111529

27

118520

1000

\*\*

(x100) M119386 M r16t127

D2855P

Purchased

No

170

Each

50.0000

1

50

**\*D2855P\***

Cap

Location

Loc Qty

Loc Code

ST

50

73347

50

\*\*

11/11/02 (50)

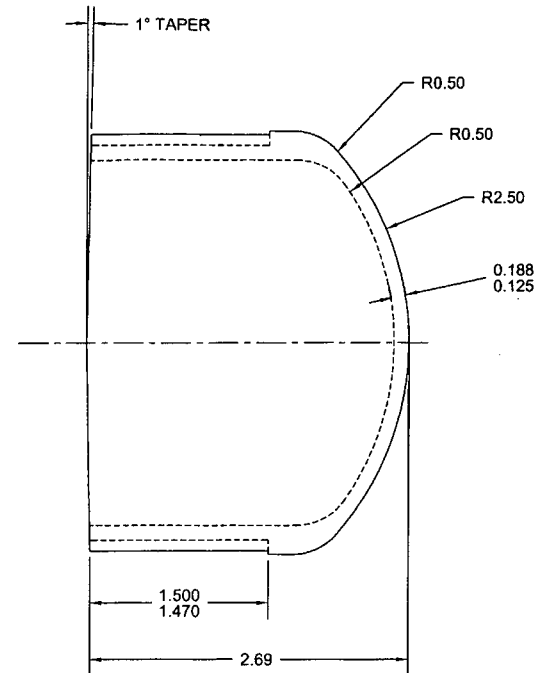
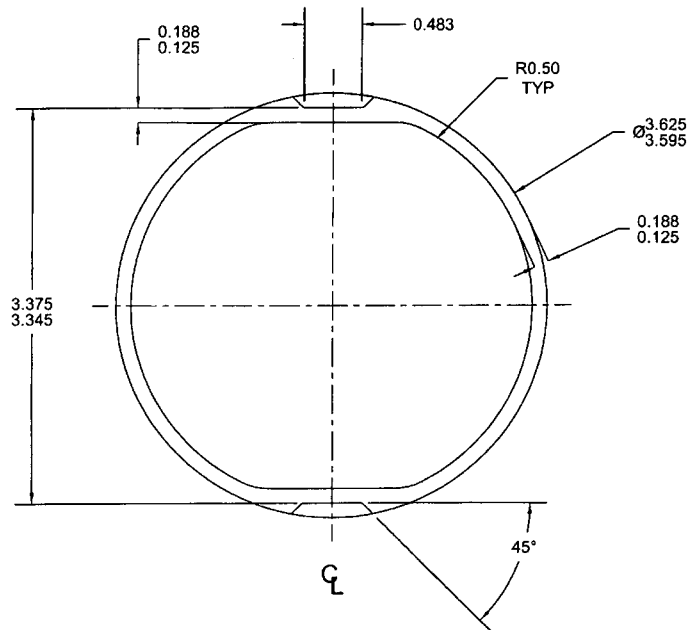
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2855C CASTING DETAIL

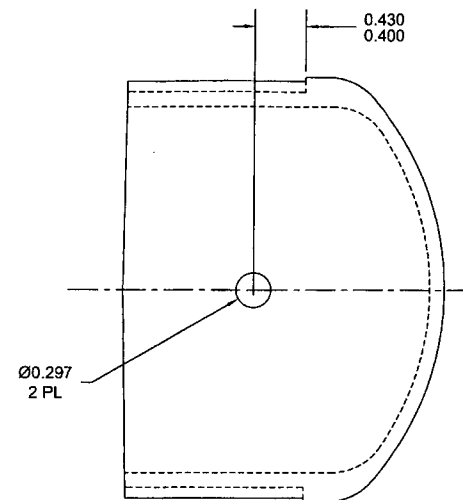
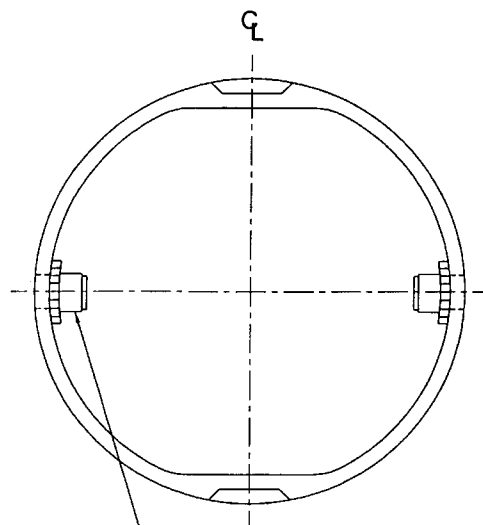


RELEASED  
09/17/15 AM

**NOTES:**

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D2855	SHEET 1 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
2 PL

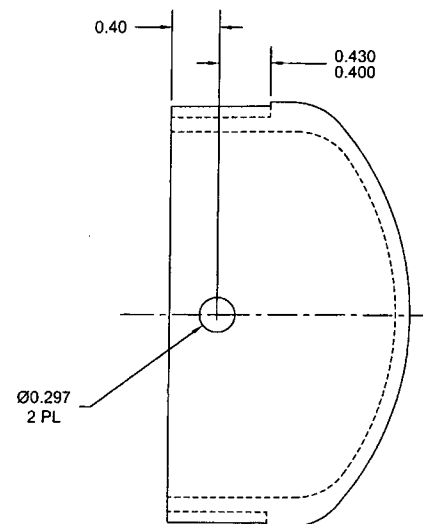
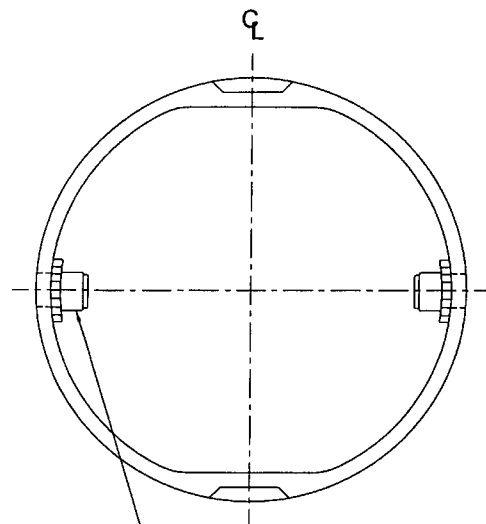
**D2855 CAP**  
(MAKE FROM D2855C CASTING)

**RELEASED**  
*3/17/15*

**NOTES:**

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: PODER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D2855	SHEET 2 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	







INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
2 PL

**D2855-3 CAP**   
(MAKE FROM D2855C CASTING)

**RELEASED**  
09/07/15 MB

**NOTES:**

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO15175**

Purchase Order Date 10/17/2011

PO Print Date 10/17/2011

Page Number 1 of 1

**Order From :**

VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.  
2225 CHEMIN ST. FRANCOIS  
DORVAL, QC H9P 1K3  
CA

11-10-17

**Contact Name**

**Vendor Phone**

514 683 9777

**Vendor Fax**

514 683 0375

**Vendor Account Nbr**

**Buyer**

Brigitte Golden

**Requisition Nbr**

**Tax Resale Nbr**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

Destination-Collect

**Ship To :**

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2855P	Cap	10/24/2011 Yes	50.00 Each	Yours ppd	\$18.1000	\$905.00
		<b>Special Inst:</b>	As per DWG: D2855 Rev:B B75074				
2	D2855P	Cap	10/24/2011 Yes	20.00 Each	Yours ppd	\$18.1000	\$362.00
		<b>Special Inst:</b>	As per DWG: D2855 Rev: B B75080				
<b>PO Total:</b>							<b>\$1,267.00</b>

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

Change Nbr: 2

Change Date: 10/17/2011

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

# Aluminum Foundry Ltd

2225 Chemin St. Francois  
Dorval, Québec H9P 1K3  
Tel: (514) 683-9777  
Fax: (514) 683-0375  
email: info@foundryafpw.com

## Packing Slip

Packing Slip No.: 33868  
Shipped Date: 01 11 2011

<b>Sold to:</b>	<b>Ship to:</b>
<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7  Tel. (613) 632-5200 Fax (613) 632-5246	<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
<b>Order No.:</b> 15175	
<b>Shipped By:</b>	
<b>Tracking No.:</b>	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	70
<div>Received by:</div> <div>Date:</div>			50
<div>Comment:</div>			

*Attn. Brigitte Golden*CERTIFICAT DE CONFORMITÉ  
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD2225 Chemin St. Francois, DORVAL, QC H9P-1K3  
TEL : (514) 683-9777 FAX: (514) 683-0375Expédié à  
Shipped**DART AEROSPACE**

A.F. &amp; P.W.Série no./Serial no.

**1270 Aberdeen Street**

Packing

Date: **01/10/2011** Slip No. **33868****Hawksbury, ON, K6A 1K7**Vôtre No. Commande **15175**

Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificates di détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
70pcs	D 2855 CAP	Z098046	A356.2	ingot#C626-1723 B#1130401

Analyse  
Analysis (as in Ingot)

(Si)	7.20%	(Al)	balance
(Fe)	0.11%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.40%		
(Zn)	<0.01%		
(Ti)	0.12%		

Donne  
Yield :Résistance a la tension :  
Tensile Strength :Allongement par pouce carré :  
P.S.I. Elongation :

%

Pour et au nom de  
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :  
Par/Per :

Coc-100